

Date: Wednesday, 1/23/2008 12:06:17 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WELDMNT TOP PANEL
Job Number	: 36941 -1		
Estimate Number	: 13028		
P.O. Number	:	Part Number	: D36501
This Issue	: 1/23/2008 S.O. No.	Drawing Number	: D3650 REV.B U/R
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B U/R
Previous Run	: 35707	Material	:
Written By	: _____	Due Date	: 2/29/2008 Qty: 2 Um: Each
Checked & Approved By	: _____		
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC		
	: Est Rev:B ECN 1113P 08-01-22 DD		

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S26GA	304/316 0.018 SHEET	
Comment: Qty.: 1.6622 sf(s)/Unit Total : 3.3243 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: 106996 B 8-2-4			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D3650 Dwg Rev: B B 8-2-4 Prog Rev: B 2-Deburr if necessary B 8-2-4			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
Comment: SECOND CHECK 508/02/04 (2)			
5.0	BRAKE NC	NC BRAKE	
Comment: NC BRAKE Form as per Dwg D3650 508-03-12 (2)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 36941

Part Number: D36501

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

MS20427M33

Rivet



Comment: Qty.: 18.0000 Each(s)/Unit Total: 36.0000 Each(s)

Rivet

batch: M106780

8.0

MS210603K

Nut Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut Plate

batch: M105938

9.0

MS210623K

Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut Plate

batch: M105938

10.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Assemble as per dwg D3650

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: POP 38103

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

POSITIVE RECALL

EFFECTIVE 08.03.13 AUTH W

RELEASED 10 DATE 08.03.13

Job Completion





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 36941
Description: WELDMENT TOP PANEL		Part Number: D3650-1
Inspection Dwg: D3650-1 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	X			
Ø .213	+ .005 - .001	.213	X			
Ø .250	+ .005 - .001					
17.58	+/- .030	17.58	X			
12.25	+/- .030	12.25	X			
12.02	+/- .030	12.02	X			
16.61	+/- .030	16.61	X			
15.80	+/- .030	15.80	X			
3.950	+/- .010	3.950	X			
140	+/- .030	140	X			
2.02	+/- .030	2.02	X			
4.03	+/- .030	4.03	X			
6.13	+/- .030	6.13	X			
8.23	+/- .030	8.23	X			
10.31	+/- .030	10.31	X			
2.26	+/- .030	2.26	X			
7.18	+/- .030	7.18	X			
9.55	+/- .030	9.55	X			
10.66	+/- .030	10.66	X			
16.65	+/- .030	16.65	X			

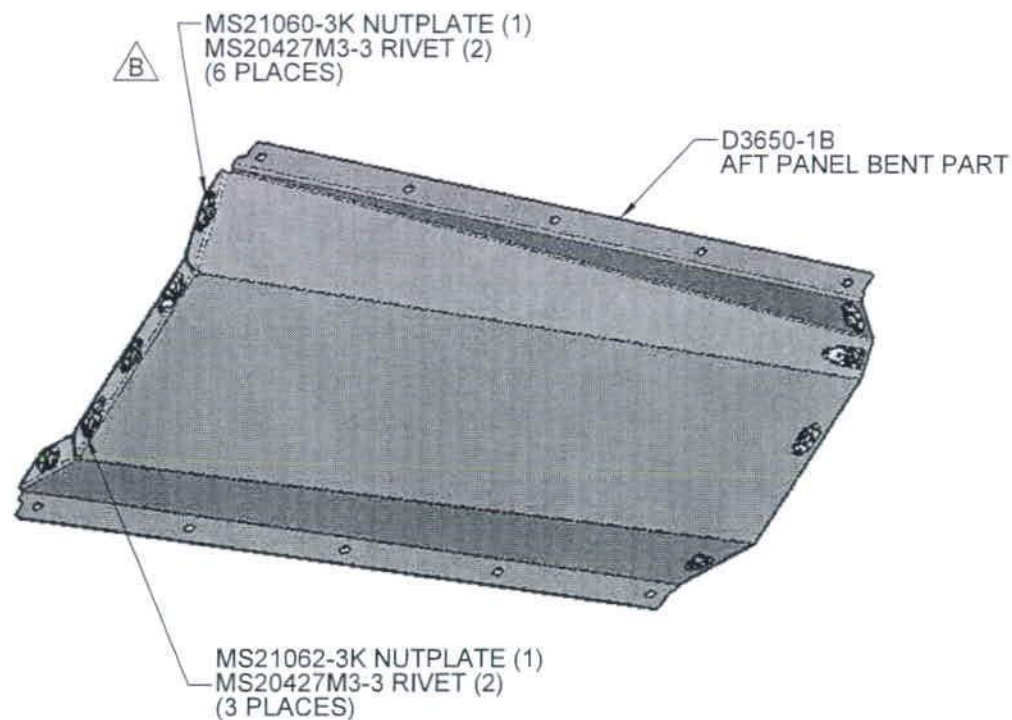
Measured by: IB	Audited by: [Signature]	Prototype Approval: LE
Date: 8-2-4	Date: 08/2/04	Date: 08-03-13

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Signature]







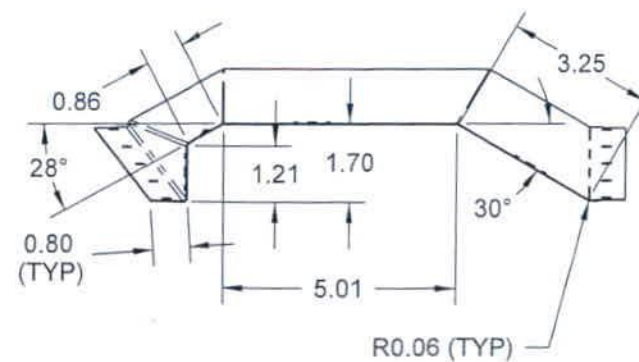
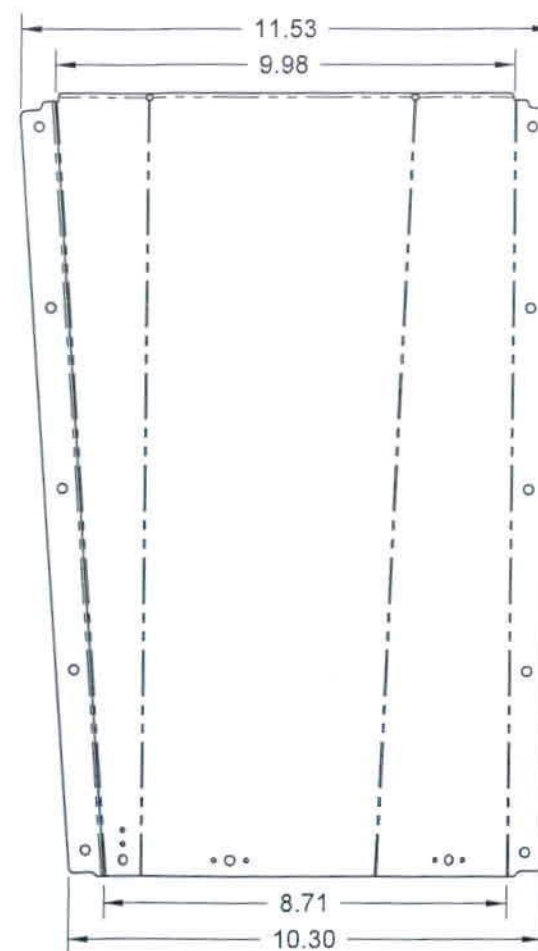
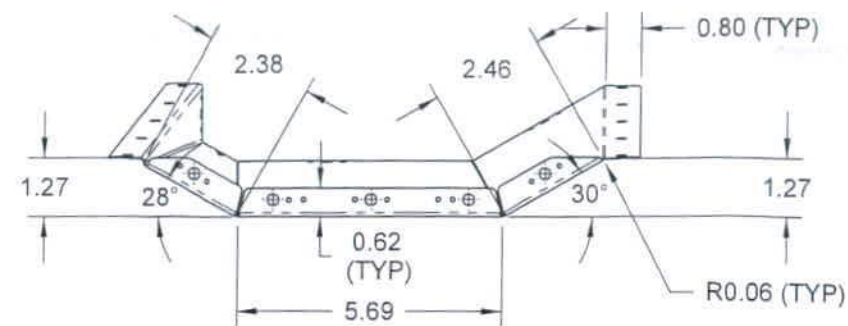
**D3650-1 AFT PANEL**

**PART LIST**

QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

**NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) WEIGHT: 1.3 lbs



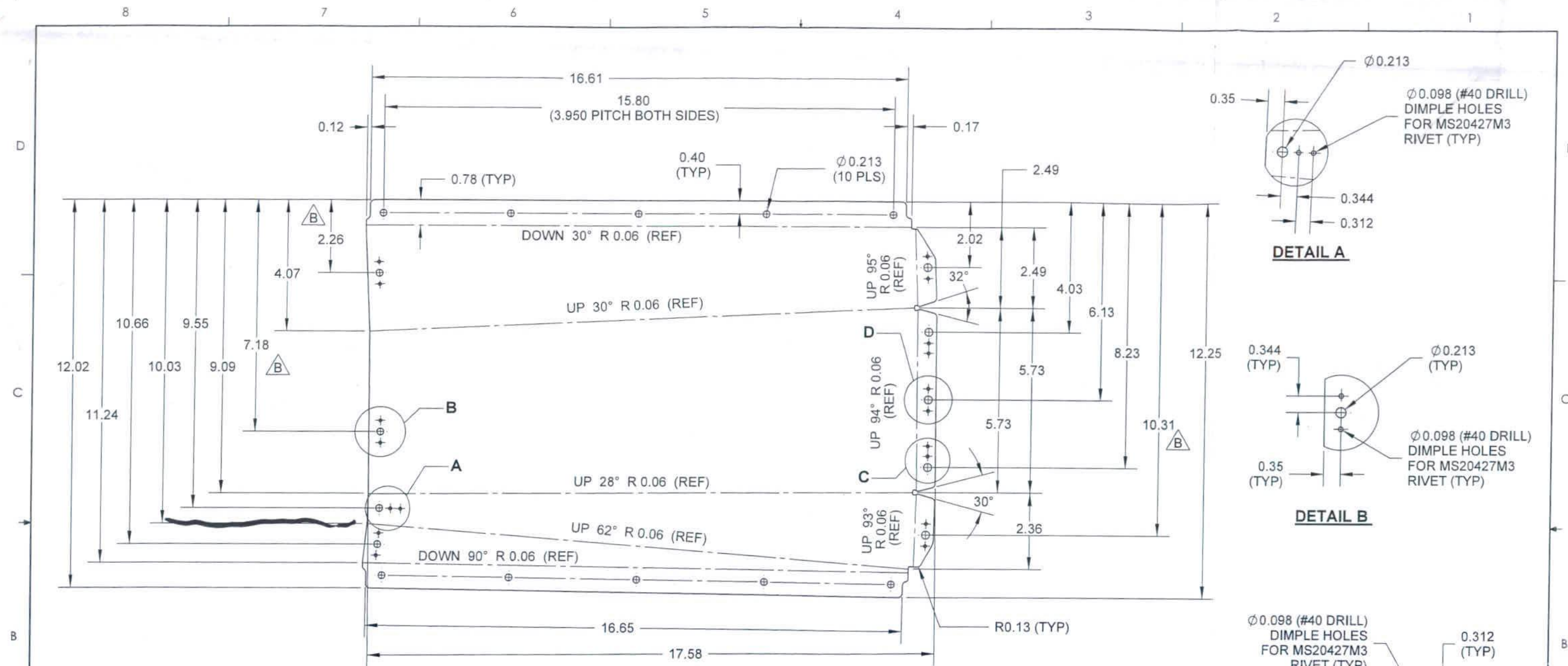
**D3650-1B AFT PANEL BENT PART**  
(MAKE FROM D3650-1F FLAT PATTERN)

**PRELIMINARY ISSUE**  
VE 08.01.18

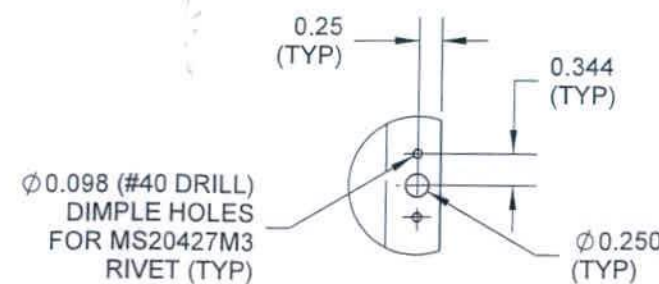
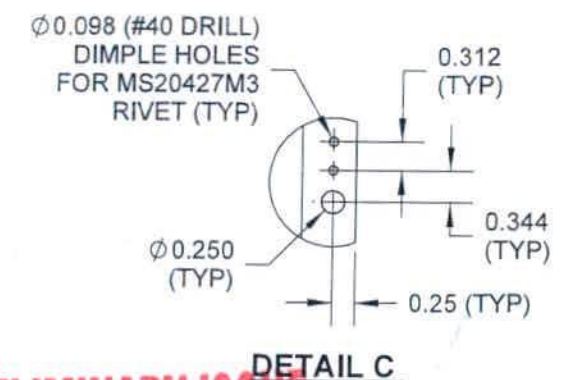
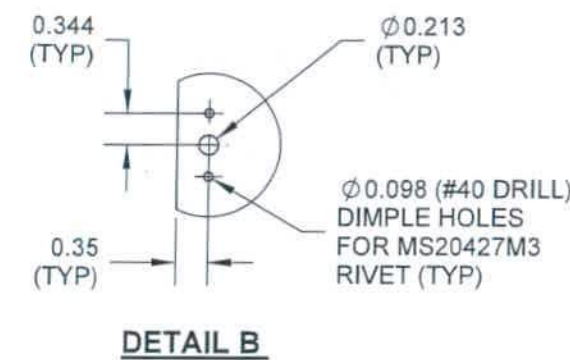
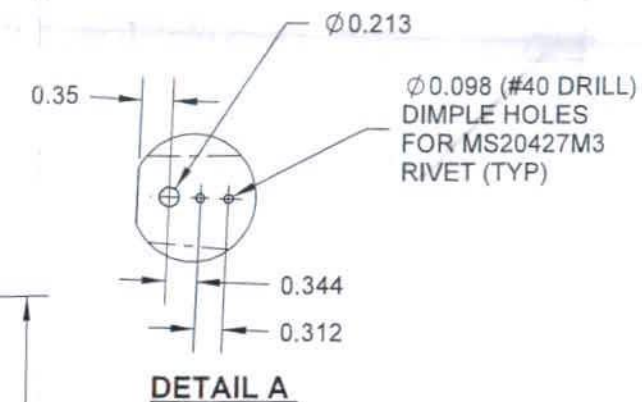
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3650</b>	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>TOP PANEL ASSEMBLY</b>	1:4
DATE	<b>08.01.07</b>	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			







**D3650-1F FLAT PATTERN**



**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.22 lbs

**DETAIL D**

**PRELIMINARY ISSUE**  
08.01.07

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D3650</b>	REV. B
MFG. APPR.			SHEET 3 OF 9
APPROVED		TITLE <b>TOP PANEL ASSEMBLY</b>	SCALE 1:3
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.01.07		





8 7 6 5 4 3 2 1

D

C

B

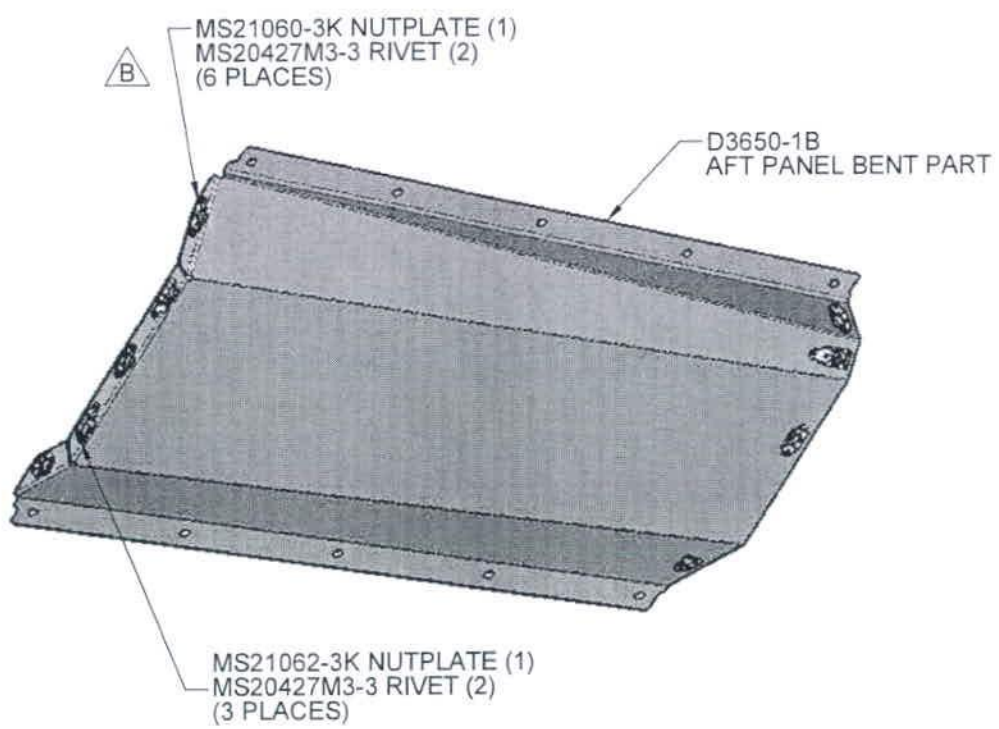
A

D

C

B

A



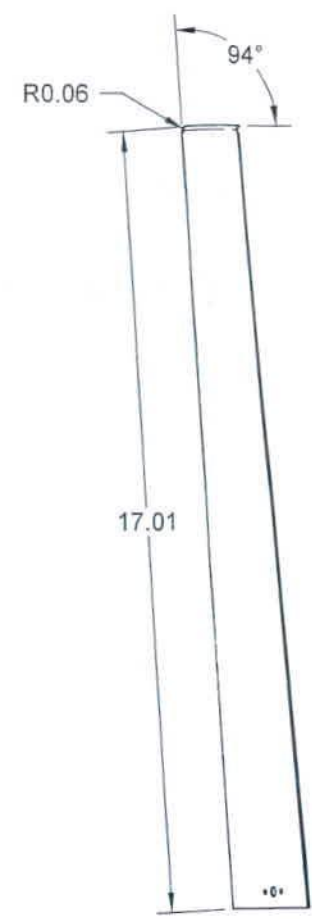
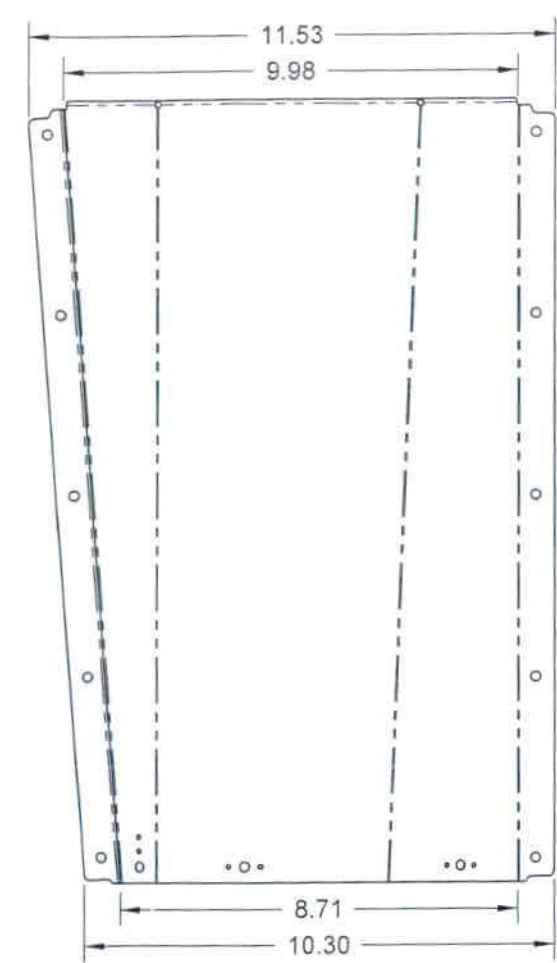
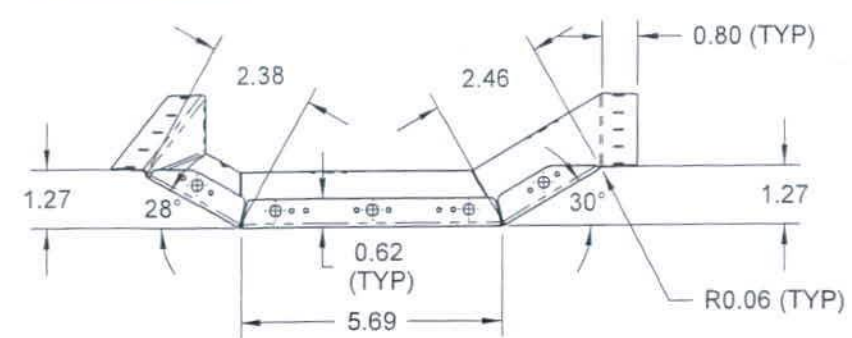
**D3650-1 AFT PANEL**

**PART LIST**

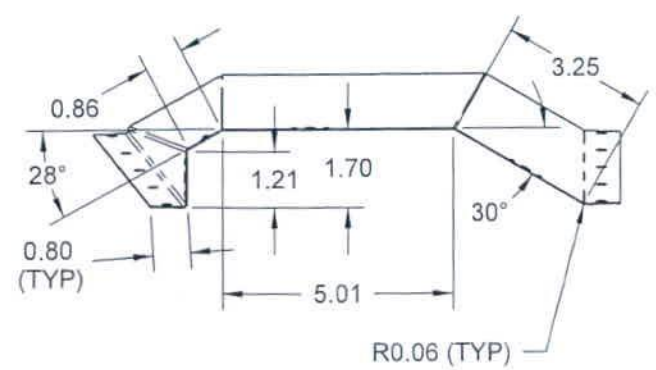
QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

**NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 5) IDENTIFICATION: NONE
- 6) WEIGHT: 1.3 lbs



**D3650-1B AFT PANEL BENT PART  
(MAKE FROM D3650-1F FLAT PATTERN)**

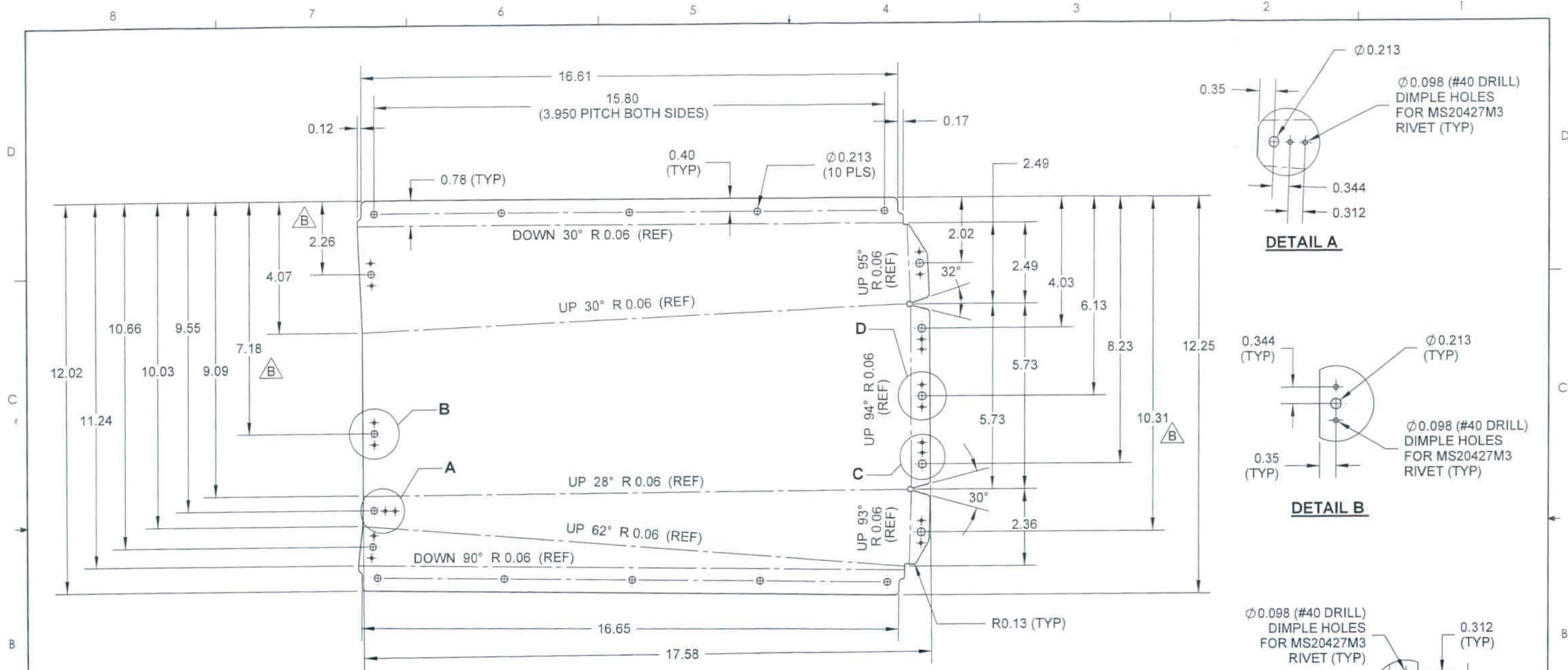


DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

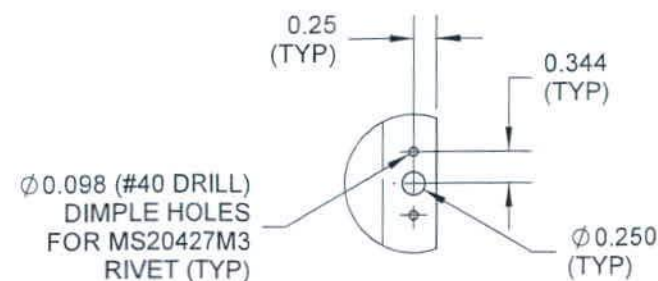
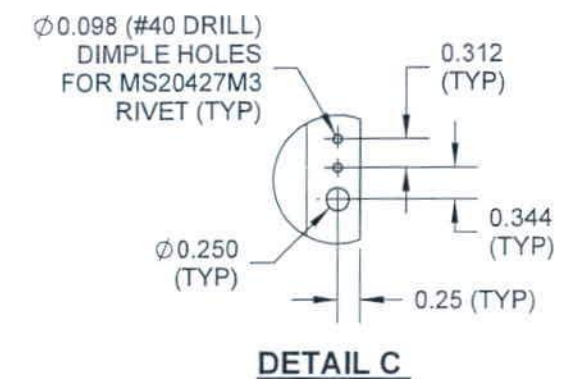
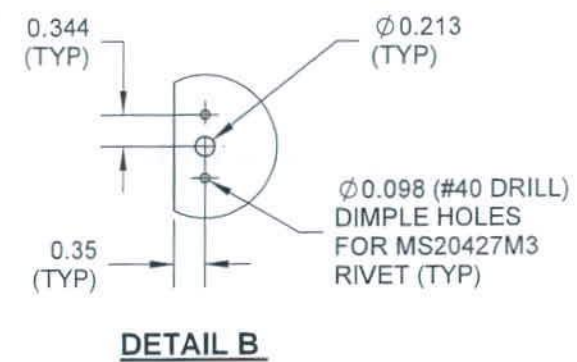
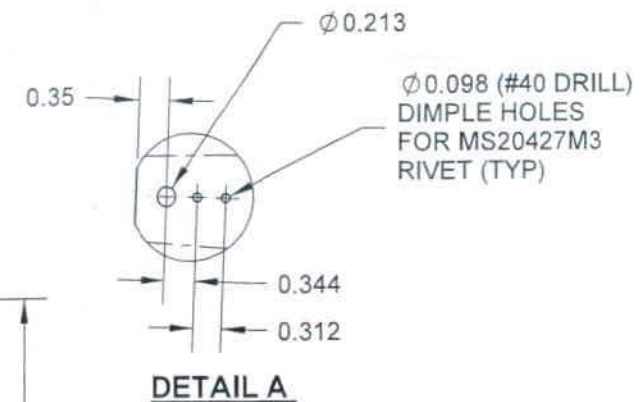
8 7 6 5 4 3 2 1







**D3650-1F FLAT PATTERN**



**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.22 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3650</b>	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>TOP PANEL ASSEMBLY</b>	1:3
DATE	08.01.07	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

